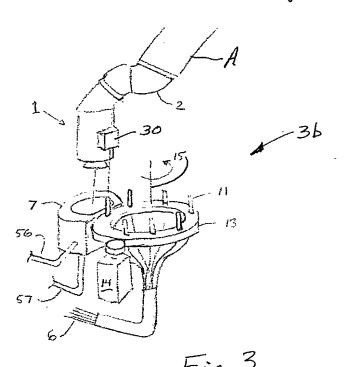
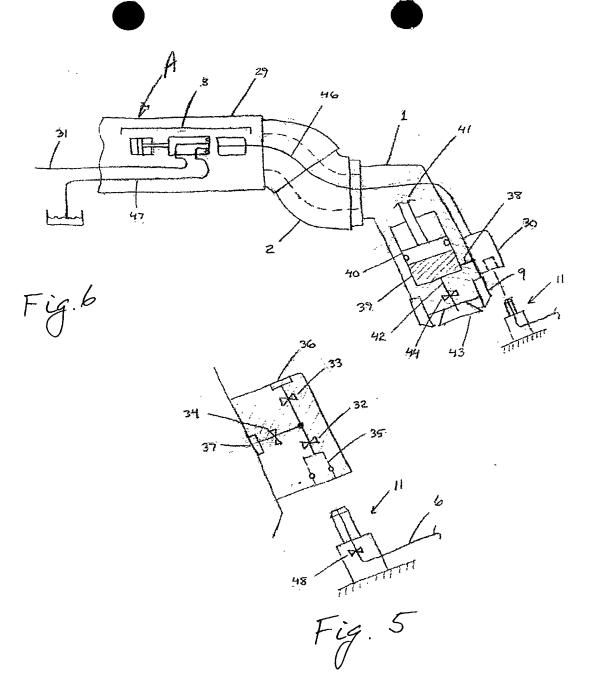


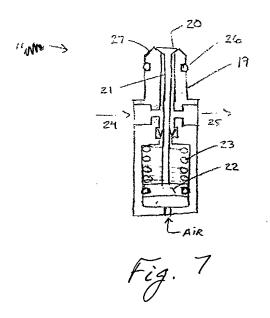
Process step	Description				Docking	Piston						
		8	52	53	55	32	33	34	44	48	position	position
Α	Finished painting green										remote	at bottom
В	Clean piston face and bell cup, index injector	on	on		on		on	on	on		remote	oscillate near bottom
C	Dock with paint supply				-						docked	at bottom
	Prime lines with red paint					on		on	on	on	docked	at bottom
D			<u> </u>			on		on		on	docked	retracting
E	Fill canister with red paint			 							noor.	at top
F	Leave dock & clean injector	on	on		on	on	on	<u> </u>			near	<u> </u>
G	Clean control valve face	on	on	on							remote	at top
Н	Paint with red								on /		remote	dispense
							1		off		Į	

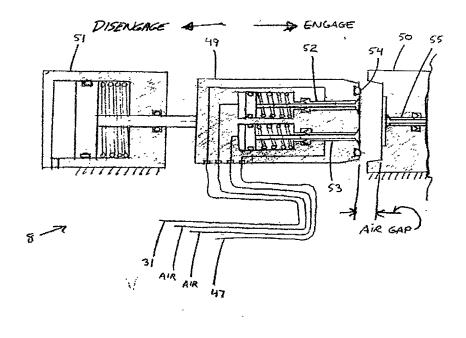
Fig.9

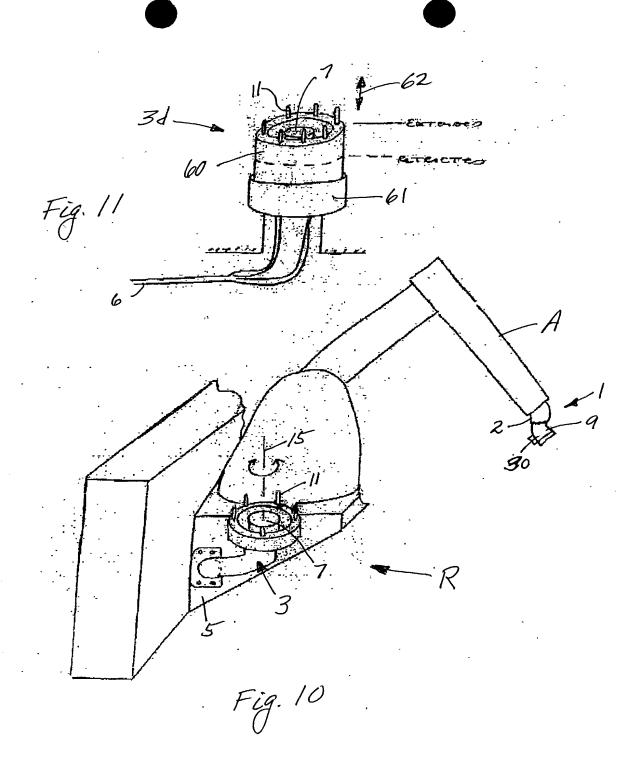


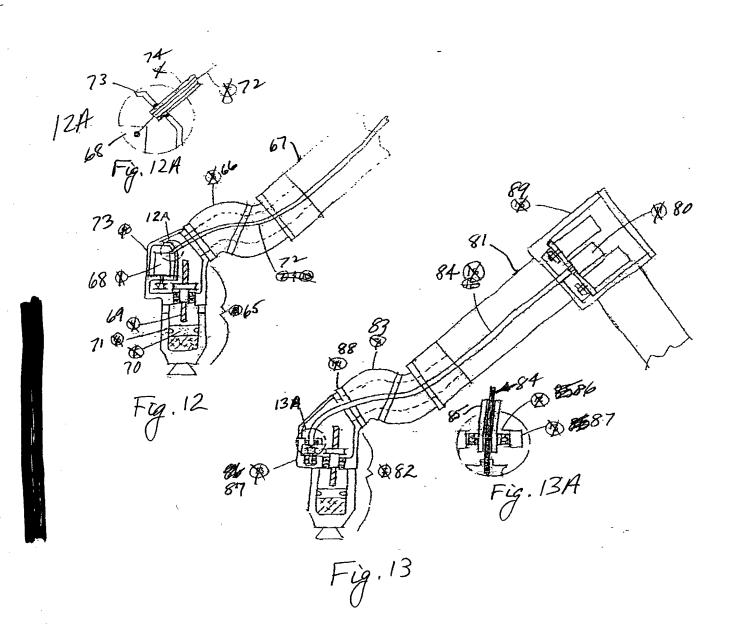


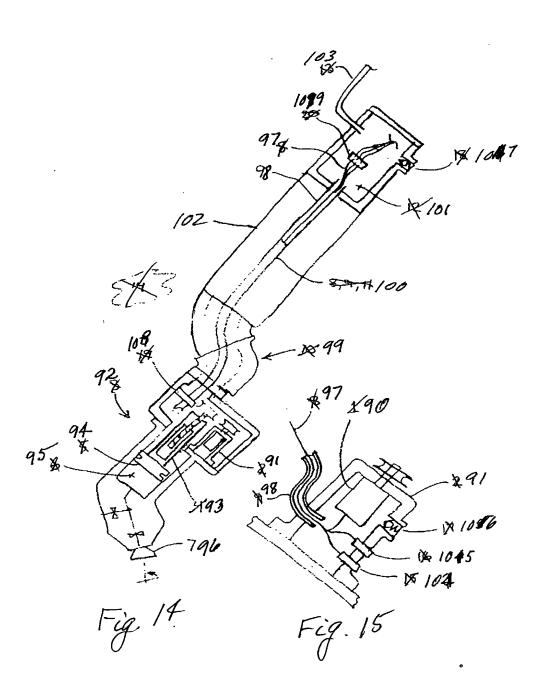
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on on

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t size polor	Docked	Valve												
Process sequence - changing color	Docked	A	В	C	D	E	F	G	Н	1:	J	K	L.	
Done painting red	no		<u> </u>		<u> </u>		<u> </u>	├-		├	 		-	
Clean piston face & inside bell cup	no	on	on	on		<u> </u>	!	├	1_	├	on	\vdash	_	
Clean outside of bell	yes/no			on		<u> </u>	1	١	lon		lou	L		
Index to green supply	yes/no valve position n/a (can be parallel pro yes valve position n/a (can be parallel pro							be parallel process)						
Clean shroud								Ces	" —	on	on			
Prime lines with green	yes	on	on	<u> </u>	on	! —	on	┼	 	┼-	┼	·	on	
Fill can with green	yes		on	<u> </u>	on	<u> </u>	on	 	╫	 	on	 "	on	
Clean & dry docking interface	yes	_	<u> </u>			on	 	┼	╂—	┼-	on	╂	۳.	
Continue drying	no			on	on	on		╂	┼─	┼-	1011	-	┼	
Paint with green	no	lon	<u> </u>	上		L	<u> </u>	ــــــــــــــــــــــــــــــــــــــ	┸_	1	<u> </u>		<u> </u>	

Valve Process sequence - refilling same Docked FGHI CDE color no Done painting red Clean inside & outside of bell yes/no valve position n/a (can be parallel process) yes Clean shroud on on on on yes Prime lines with red on on on yes Fill can with red on on on Clean & dry docking interface yes on on on no Continue drying no Paint with red PAINT SERVO MOEX

Fig. 16

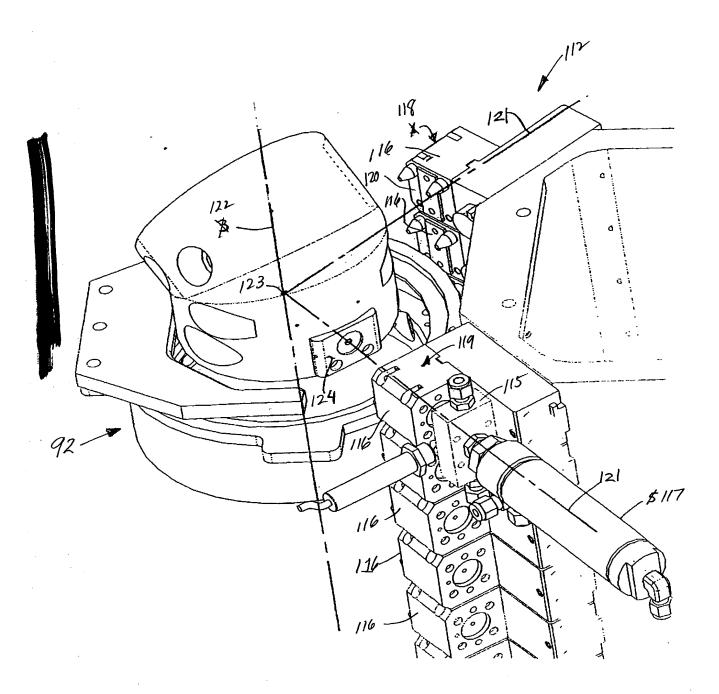


Fig. 19

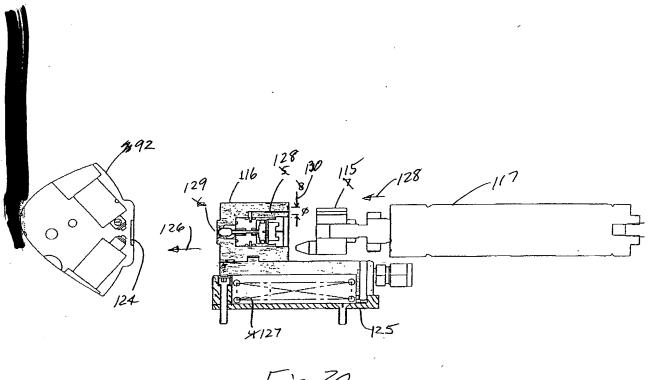


Fig. 20